

Work Order ID 137675

Wednesday, October 07, 2015 12:42:50 PM

137675

Item ID: D3845-1KIV

Revision ID:

Item Name: Hat Bin-Ivory

Start Date: 10/02/15 Start Qty: 1.00

Required Date: 10/07/15 Req'd Qty: 1.00

Reference:

1

1

Cust Item ID:

Customer:

Accept

N900040100

NS1

NS2

Approvals:

Process Plan: MLS

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

NR1

Stop

NR2

Sequence ID/

Work Center ID

Operation

Description

Set Up/

Run Hours

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

Draw Nbr

Revision Nbr

Rev C

100

0.00

100

HandThermo

Hand Finishing Thermoforming

Memo

1-Machine set up

2- Cut sheet to required blank size

0.00

1

15/11/06

DAS

07

9-89

105

105

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 KYDEX

0.00

1

15/11/06

DAS

07

5-07

Temp: 103 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

OCT 05 2015

Per...hik.....

Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Part No. _____					
NCR No. _____					
Date : _____		Step #: _____		QTY Effective : _____	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		OTHER : _____	

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Accept

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Setup

Start

NS1

Stop

NS2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/

Work Center ID

110

Operation
Description

Tool ID

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

AS
07
9-89

110

Thermoform

Thermoforming Machine

Memo

0.01

Thermoform as per Dwg. D3845 and folio FTA035 using tool DT 9255

Dwg. Rev. C

Folio Rev. C

Visually inspect for proper formation and texture

140

140

HandThermo

Hand Finishing Thermoforming

Memo

0.01

1) Trim to Finished Dimensions

150

150

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

15/11/10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐													
NCR No. _____		Suspected Unapproved ☐		QTY Effective: _____		MRB (QS1042) Approval ☐																	
Date: _____		Step #: _____																					
Description Work Order Deviation				Disposition				Completed By															
								Lead hand / Supervisor Approval Verification															
								QC / QA Coordinator Approval															
Root Cause				FAULT CATEGORY																			
Environment ☐				No Re-verification ☐				Pressure/Forced ☐				Temperature/Cure ☐				Power Loss/Surge ☐				Positioned Wrong ☐			
Design ☐				Operator ☐				Bending ☐				Set-up ☐				Folio/Program ☐				Outside Dimensions ☐			
Doc/Data ☐				Offset/Setup ☐				Centre Not Concentric ☐				BOM/Route ☐				Grain ☐				Over/Under tolerance ☐			
Equip/Tooling ☐				Supplier ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Part Incorrect ☐			
Handling/Pre ☐				Training ☐				Crimp/Kink/Ripple/Wave ☐				Inspection Incomplete/Unqualified ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Material ☐				Use for Testing ☐				Cuffs ☐				Contamination ☐				Out of Sequence ☐				Part Moved ☐			
Internal Transport ☐				Poor Information ☐				Crushing ☐				Counter-sink ☐				Off-set ☐				Drawing ☐			
Tribal Knowledge ☐				Rushing ☐				Heat Treat ☐				Cut Too Short ☐				Mis-labeled ☐				Finish ☐			
LOA ☐				Product Improvement ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐				Fit/Function ☐				Misread ☐			
Substation ☐				Process Improvement ☐				Marks/Chatter ☐				Drill Holes ☐				Misaligned/off center ☐				Turning Sequence ☐			
Past Expiry Date ☐				Manufacturing Process ☐																			
Misidentified ☐				Past Due ☐				OTHER: _____															

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS																																																			
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																				OTHER: ☐																																					

Wednesday, October 07, 2015 12:42:49 PM

Parent Item Name: Hat Bin-Ivory

D3845-1 KIV

Start Date: 10/02/15 **Required Date:** 10/07/15

Start Qty: 1.00
Required Qty: 1.00

Comments:
IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

[illegible]

MKYD6185S 125-P3-62015

Kydex Ivory (52"x96"-.125)

Work Order update only

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev 1

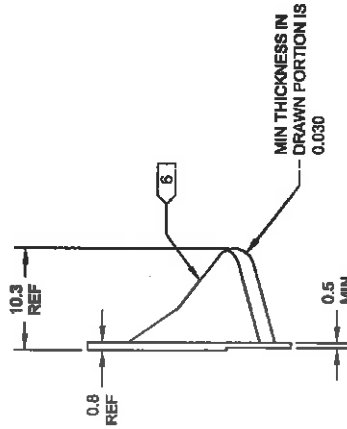
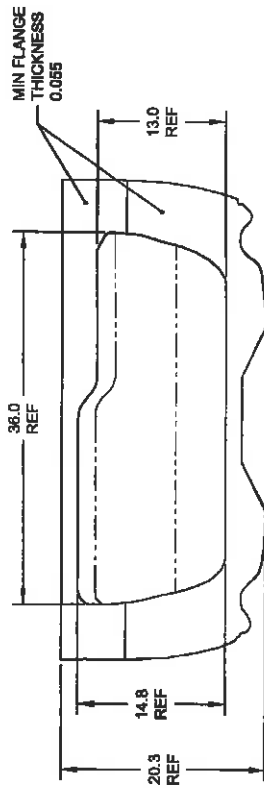
DART AEROSPACE LTD	Work Order:	137675
Description: Hat Bin	Part Number:	D3845-1KIV/KGY
Inspection Dwg: D3845	Rev: C	Page 1 of 1

Description		Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/16"					
Shape Definition		✓			
Texture Retention		✓			
Material imperfections such as bumps, cracks, voids, scratching		✓			
Measured by:		Date: 15/11/06			

[illegible]

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

1 2 3 4 5 6 7 8



D3845-1 HAT BIN
(BELL 206 L/L1)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.3 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3845-1KV	KYDEX 8185, 0.125 THICK, P3-VELOUR MATTE,
D3845-1KGY	IVORY #62015 (MKYD6185S-125-P3-62015)
	KYDEX 8185, 0.125 THICK, P3-VELOUR MATTE,
	STEEL GRAY #52088 (MKYD6185S-125-P3-52088)

REV.	DESCRIPTION	BY	DATE
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3845-1KV AND ADD STEEL GRAY P/N D3845-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN AT-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.22

DESIGN	DART AEROSPACE LTD
DRAWN	HAWKESBURY, ONTARIO, CANADA
CHECKED	DRAWING NO. D3845
MFG. APPR.	REV. C SHEET 1 OF 1
APPROVED	TITLE HAT BIN (BELL 206 L/L1)
DE APPR.	SCALE NTS
DATE	09.05.05

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137675 MLS
15-10-08

RELEASED
R 09/15/2008

